

ASAP

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:08:47 PM
User: Julie Lecocq

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STEP WELDMENT

Job Number : 41039 -2

Estimate Number : 12577

P.O. Number :

This Issue : 06/08/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1 Type : LARGE FAB ASSY

Previous Run : 40289

Part Number : D3562042

Drawing Number : D3562 REV E

Project Number : N/A

Drawing Revision : E

Material :

Due Date : 29/08/2008

Qty: 3 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev:A New Issue 06-11-09 JLM
Est rev B ECN 987 07.10.09 EC verified by: DD
Est Rev:C ECN1048 07-12-18 DD verified by: EC
Est Rev:D 08-07-28 add chemical conversion coat DD
verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion B40937

Check Material for any Dents or Defects

SAD 08/08/28 5

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/28 3

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/08/29 15

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HJ 08-09-03 15

Date: Wednesday, 06/08/2008 2:08:47 PM
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Drawing Name: STEP WELDMENT

Job Number: 41039

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

D3560042

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: 341281

B41287 (2) - gone to labalard
B42369 (1)

SAD 08-12-18

08.09.08

7.0

D3560044

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: 335298

B41288

SAD 08-12-18

08.09.08

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 160.0000 Each(s)

Blind Rivet

batch: m108990

64x
m108990

m108990

SAD 08-12-18

08.09.08

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

SAD 08-12-19 (3)

08.09.08

2- Rivet legs using Magnabond as per dwg D3562.

SAD 08-12-19 (3)

08.09.08

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: m108966
M106695

SAD 08-12-19 (3)

08.09.08

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08-12-19 (3)

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

B39179

08.12.22

Date: Wednesday, 06/08/2008 2:08:47 PM
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Job Number: 41039

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PHD

Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *m109560*
m108037

2-Grind end cap welds flush as per Dwg D3562

08-12-22 8

08-12-23 8

SAD

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-12-23 8

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/09 12

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

+ PRESSURE WASH

HL

09-09-01

(12)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 09/01/09

(2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *m109917*

FL 09/01/09

(2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION




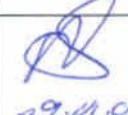
M- 09/01/09

(2X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41039</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/08	9.0 12.0	Small peice of mega band dropped inside Step		drill small hole to remove debris from step Fill with weld Buff weld flush	SAP 09-01-08 Lpl 09-01-08 09-01-08 SAP	 080108	 0742	 09-01-08

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify & Stock Pick Assembly Kit - G-A

CB 09/01/12 (2)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



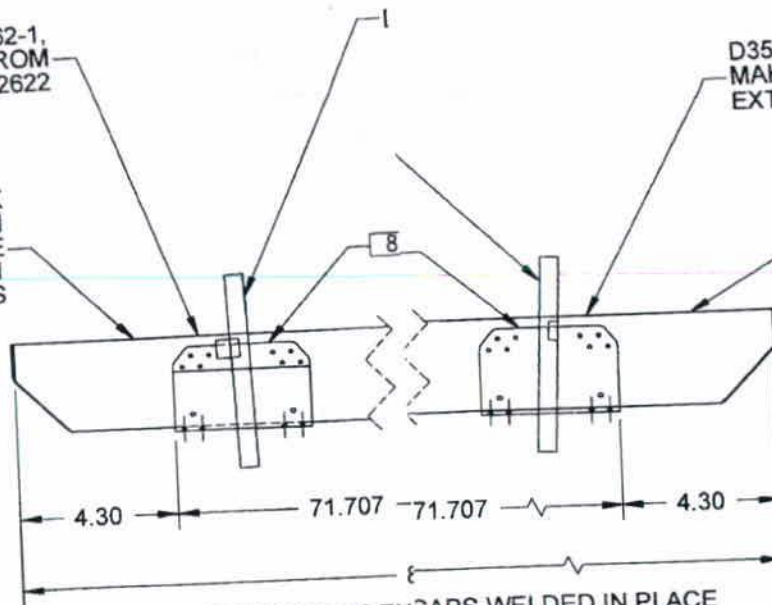
MF 09-01-12

D3562-1,
MAKE FROM
EXTRUSION D2622

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS



MEASURED BEFORE ENCAPS WELDED IN PLACE

FWI

D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP SPACER NOTE; REDRAWN IN
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE, ADD D2808, REMOVE 4 RIVETS
GREY SAND TO STEP

GREY SAND

BLACK SAND

GREEN SAND

iii) BLACK ANTI-SKID PAINT PER DART QSI

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF
THE ARM WELDMENT AND STEP EXTRUSION
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE

9) WELDING: PER DART QSI 004

2734 END PLATE ON D3562-042	PH	08.01.11
SPACER NOTE; REDRAWN IN	DC	07.11.16
ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
ED TO STEP	CP	07.01.15
	CP	06.09.26
DESCRIPTION	BY	DATE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3562

REV. E

SHEET 1 OF 1

TITLE

STEP ASSEMBLY

SCALE

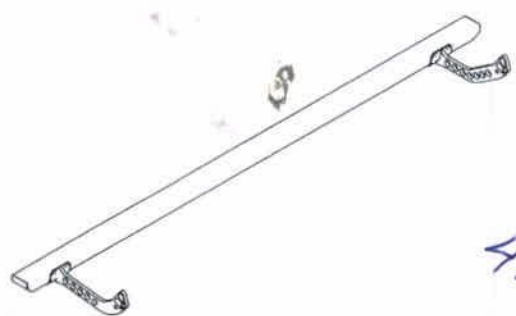
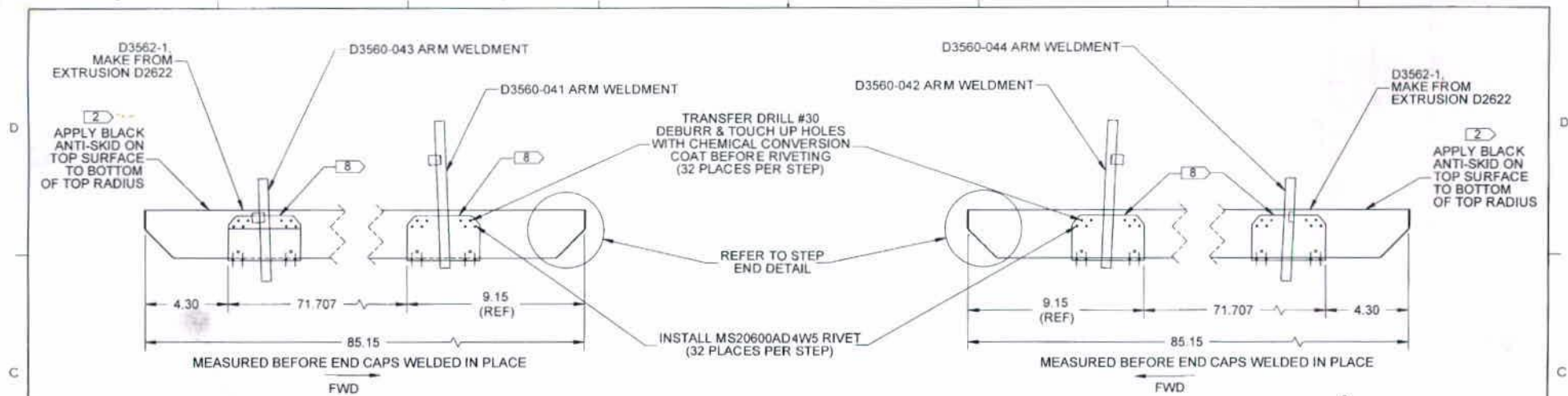
1:5

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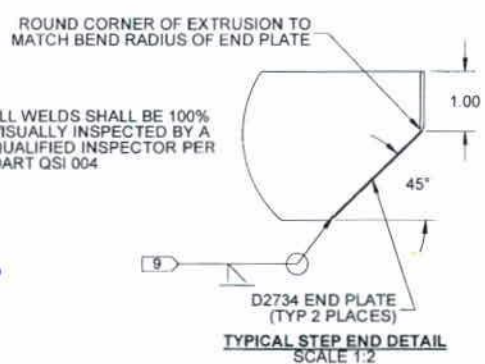
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NO. 41039

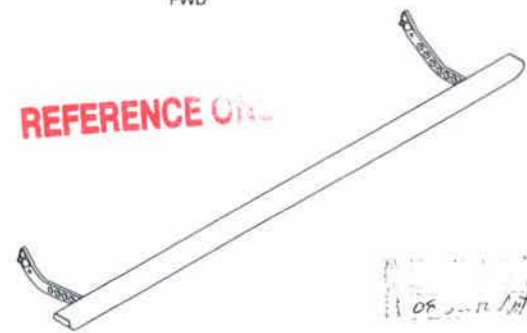
41039



D3562-041 LH STEP ASSEMBLY



**TYPICAL STEP END DETAIL
SCALE 1:2**



D3562-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1		D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
1		D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND. ADD D2808. REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	GP		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562**

TITLE **STEP ASSEMBLY**

REV. E
SHEET 1 OF 1
SCALE 1:5

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